

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029024**Date Inspected:** 23-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Chris Bruce #8901:

Welder was observed performing weld repairs on Electro Slag Weld ESW W-043 "V" at Face A, on indications rejected with Ultrasonic Testing Shear Wave and excavated at Y 8150 & 8810. Welder was observed preheating the weld to 300 degrees Fahrenheit prior to welding. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW) as per Request for Weld Repair or RWR 201301-029 & 031. Welding parameters were verified by QC Inspector William Sherwood throughout the day and appear to be in compliance with the WPS noted above. See details below.

Weld ESW W-043 V (Fc A):

Y location: 8150, Excavation: 160 x 40 x 37, RWR: 201301-029.

Y location: 8810, Excavation: 130 x 45 x 45, RWR: 201301-031.

Welder Eric Sparks #3040:

Welder was observed performing weld repairs to weld ESW E-043 Q at Face B, in way of the excavation 1025 x 30 x 20 deep at Y location 8750. The weld was preheated to 300 degrees Fahrenheit with the Miller Pro Heat induction blankets prior to welding. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW) as per Request for Weld Repair or

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RWR 201301-038. Welding parameters were verified by QC Inspector William Sherwood throughout the day and appear to be in compliance with the WPS noted above.

Welder James Zhen #6001:

Welder was observed excavating weld ESW E-045 "F" at Face A in 1mm increments at Y location 9620. Each 1mm excavation was achieved with a grinder and was observed Magnetic Particle Tested (MPT) and photographed by QC Inspector Steve Jensen or William Sherwood as their work scope allows. The excavations started from 30mm deep from the previous shift, and was continued until the end of the shift at 36mm deep. The 2mm indication at 30mm deep was ground out at 32mm deep, with no other indication noted thru the rest of the shift. The excavation of the weld will continue on the next shift until a depth of 40mm has been reached. Welder was observed grinding through the whole shift.

Non-Destructive Testing (NDT)

This QA performed non-destructive testing on the following:

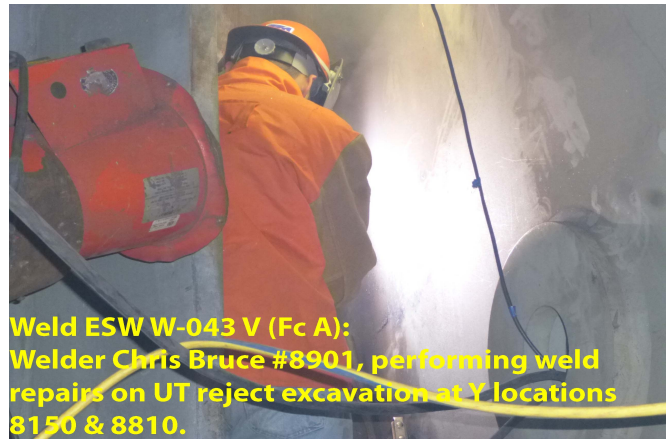
Weld ESW E-045 "F" (Fc A) :

Y 9620, 1mm Incremental Excavations from 30mm to 36mm deep. (MPT Accept).

TL-6028 was not required for this MPT.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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**Weld ESW E-043 Q (Fc B):
Welder Foreman Eric Sparks #3040, performing
weld repairs of UT reject excavation (1025 x 30 x
20 deep) at Y location 8750.**

Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
